

Work Order ID 78347

Thursday, January 05, 2012 2:56:37 PM

78347

Page 1

Item ID: D4003-049 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tank Vent Line Assembly
Start Date: 1/6/2012 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/27/2012 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: mf Date: 12-01-06 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4003	A

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15900
Manufacture as per Dwg D4003
Ship mat'l to vendor
Possible Supplier: Cintube
Material release note required

CL 12/01/17 5

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

(Signature) (Signature)
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00		8/12/02/08					
Quality Control									
124	Chemical Conversion Coat per QSI005 4.1	0.00							
124									
HandFinish	Memo	0.00							
Hand Finishing									
127	QC3- Inspect Part Finish	0.00							
127									
QC	Memo	0.00							
Quality Control									

4 6 12/02/08

4X/12/02/08

W/O:		WORK ORDER CHANGES					
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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tank Vent Line Assembly

Stop ***NS2***

Start Date: 1/6/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **193**

0.00

130

Packaging

Memo

0.00

Packaging

12/2/85 **(4)**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

M.C.J **12/02/08** **(4)****M.C.J** **12/02/08** **(4)**

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 78347

Parent Item: D4003-049

Parent Item Name: Tank Vent Line Assembly

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.05 new Issue Prelim EC verified by: DD IPP Rev B 10.05.13 ecn 10-562
EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-8D Nut		Purchased	No			100	Each	12.0000	1	5 C2 12/01/17			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST325		12							
				118112		4							
				118891		8				5			
D4003-049P TANK VENT LINE ASSEMBLY		Purchased	No			110	Each	0.0000	1	5			
M6061T6T0.500W.035 6061-T6 RD Tube .500 x.035W		Purchased	No			100	f	107.3600	1	5 x 1.5' 8 7.5 9.			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT014		107.36							
				4692		107.36				4692			
MS20819-8D Sleeve		Purchased	No			100	Each	40.0000	1	5 C2 12/01/17			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST323		40							
				118840		20				5			
				119531		20							

Dart Aerospace Ltd

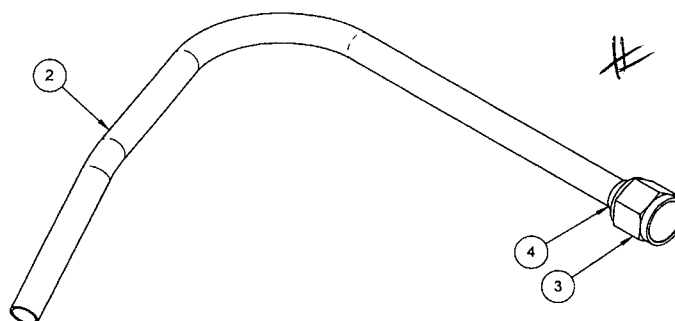
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
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NOTE: Date & initial all entries

ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

RELEASED
R 2010-05-05
MPS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4003	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		LINE	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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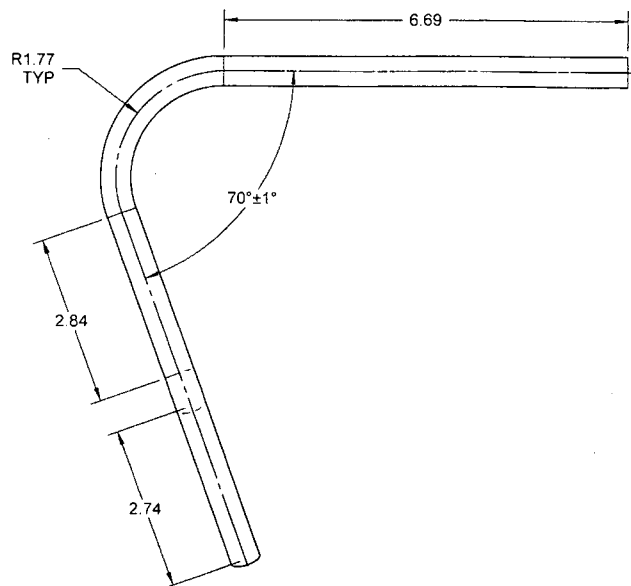
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

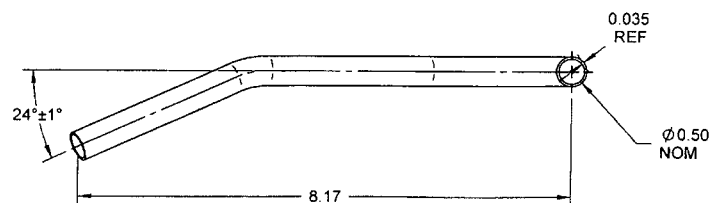
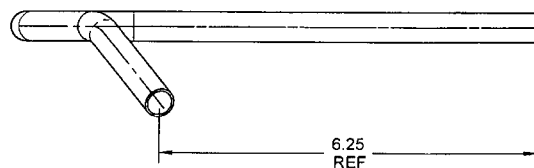
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17



78347



D4003-9 VENT LINE

RELEASED
2010-05-05
JW

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.500 \times 0.035$ WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4003	SHEET 7 OF 9
APPROVED			TITLE	SCALE
DE APPR.			LINE	NTS
DATE	10.02.05		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15900

Purchase Order Date 1/17/12

PO Print Date 1/17/12

Page Number 1 of 1

Order From :

VC-CIN001

CINTUBE LTEE
333 ST-JOSEPH BLVD
LACHINE, QC H8S 2K9
CA

Contact Name

Vendor Phone

514 634 3592

Vendor Fax

514 636 3336

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

02/20/17

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4536-041P PRELIM	Gearbox vent line	1/27/12 Yes	1.00 Each	FedEx PI collect	\$480.0000	\$480.00
Special Inst:			AS PER DWG D4536 REV. PA1 B78299				
2	D4003-049P	TANK VENT LINE ASSEMBLY	1/27/12 Yes	5.00 Each	FedEx PI collect	\$175.0000	\$875.00
Special Inst:			AS PER DWG D4003 REV. A B78347				

PO Total:

\$1,355.00

Change Nbr:

1

Change Date: 1/17/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

CLIENT: Page 1 of 1
DART AEROSPACE LTD.
1270 ABERDEEN ST.

HAWKS BURY
ON K6A 1K7

EXPED. A/T O :
SAME

M-117984

CINTUBE LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 105 ☐ 1250 MATHESON BLVD. EAST
LACHINE, QUEBEC MISSISSAUGA, ONTARIO
H8S 2K9 L4W 1R2
TEL: (514) 634-3592 TEL: (905) 625-190
FAX: (514) 636-3336 / 8625 FAX: (905) 625-1500

Rep: PATRICK ZALATAN

CLIENT

BON. LIVR.:	RELACHE
PACK. SLIP	M-117984
DATE:	25-Jan-12
COMMANDE #:	PO15900
ORDER #:	

CLIENT NO.	MAT'L PAR / MAT'L BY	REFERENCE	MODE DE PAIEMENT / TERMS OF PAYMENT
MDAR72	CLIENT		1.5 % - 10 DAYS / NET 30
TRANSPORT		DATE LIV. / DELIV. DATE	CONTACT
PUROLATOR COLLECT #7684382		7 A/T O 10 JOURS/DAYS	CHANTAL LAVOIE

CONTACT PHONE #: (613) 632-9577 EXT. #:

FAX #: (613) 632-1053

QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L. / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
1	I	0.5 OD	0.035	SMLS TUBE SS/304L	6 BENDS		SEE DRWG: D4536	FINAL CUT & FLARE ONE END
5	H	0.5 OD	0.035	PART NO. DART D4003-9 TUBE ALUMINIUM	MULTIPLE BENDS	1.77 CLR	SEE DRWG: D4003-9	FINAL CUT & FLARE
1	I			NUTS & SLEEVES BY DART LETTRE DE CONFORMITE				

Notes:

CATEGORIE ISO
ISO CATEGORY

1	2	3
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

ASME

☐

DATE CLIENT AVIS. / ADV.:

EXPEDIE PAR / SHIPPED BY:

Mane

CERTIFICAT D'ANALYSE
MILL TEST CERTIFICATE

OUI
YES ☒

LETTRE DE CONFORMITE
LETTER OF COMPLIANCE

OUI
YES ☒

CONTACT:

PAR/BY:

CLIENT:

DATE:

DATE: 6-02-12

CINTRAGE DE PRÉCISION, DE TUBES, TUYAUX, CORNIÈRES, POUTRES,
PROFILES EN "U", ET SERPENTINS.
MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.

PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,
WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

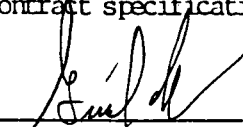
333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 2K9
TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3336

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD Date: FEB.03/2012
N° de commande du client/Customer order No: PO 15900
Notre n° de feuille de route/Our order No: 117984
Notre n° de dessin/Our drawing No: —
Description/Customer drawing No: D-4003-9 rev. A D4536 rev. PA1
Nom de la piece/Part Name: VENT LINE VENT LINE
8/12/08 4 pièces 1 pièce

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by: 

G. HOULE POUR B. OVERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltee/On behalf of Cintube Ltd.